

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85550

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/8/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/27/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

ME
12-06-14

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NOTE: Date & initial all entries

Picklist Print

Monday, June 11, 2012 10:06:37 AM

Page 1

Work Order ID: 85550

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 6/8/2012

Required Date: 6/27/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC IPP RevA 11.01.26 RevB dwg
EC verified by:DD IPP RevC 11.07.20 per PD1 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4271-025 End Fitting Assembly Fwd Beam		Manufactured	No			100	Each	1.0000	1	1		6/12/06/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST512		1							
				72266		1							
D4275-1 Fwd Beam		Manufactured	No			100	Each	4.0000	1	1		6/12/06/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST167		4							
				82642		4							
AN3C12A Bolts		Purchased	No			100	Each	239.0000	6	6		6/12/06/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		38							
				120449		38							
				ST351		201							
				117514		4							
				118112		5							
				118451		22							
				119510		1							
				120423		65							
				121259		4							
				121584		50							
				121689		50							

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Picklist Print

Monday, June 11, 2012 10:06:37 AM

Page 2

Work Order ID: 85550

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 6/8/2012

Required Date: 6/27/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

100

Each

1,439.0000

6

6

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1367

118077

2

118614

51

118686

30

119758

20

121255

270

121708

994

NAS1149C0332R

Purchased

No

100

Each

906.0000

12

12

Washer

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

687

121255

20

121509

667

M122063

(122)

Monday, June 11, 2012 10:06:37 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

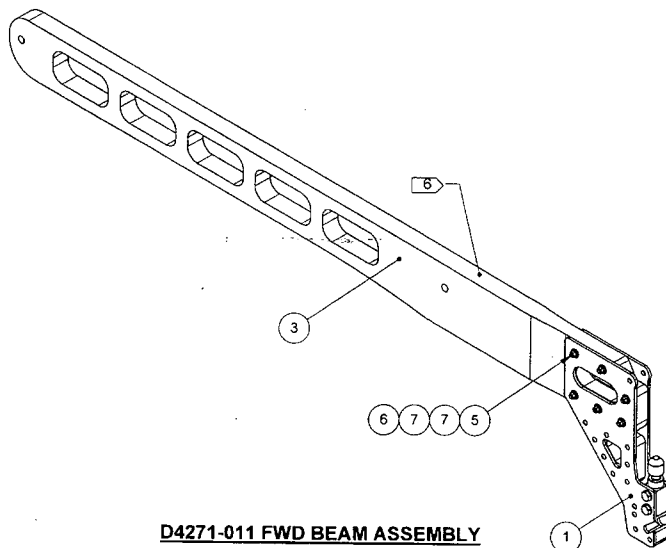
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

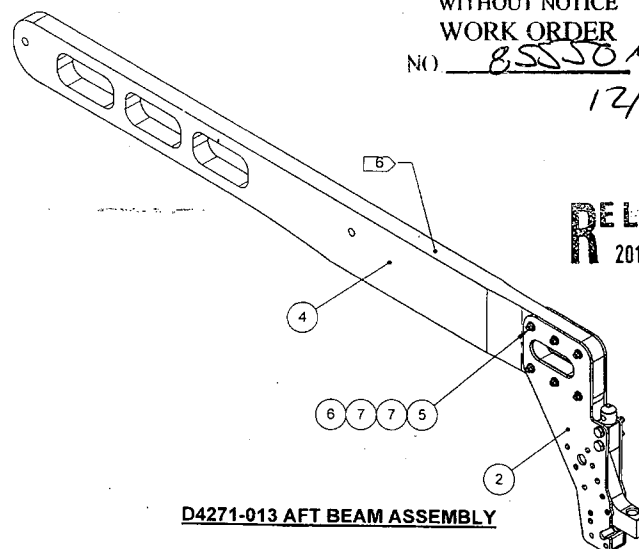
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ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 85550 MLJ
12/06/12

RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD — HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4271 REV. D SHEET 1 OF 3 TITLE SUPPORT BEAM ASSEMBLIES NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	JP		
MFG. APPR.	E		
APPROVED	JP		
DE APPR.	JP		
DATE	11.07.14		

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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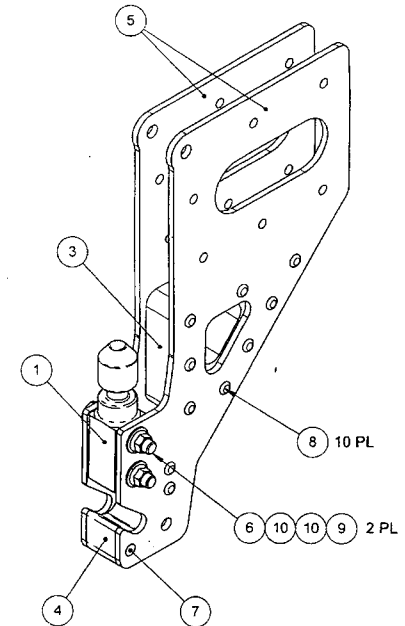
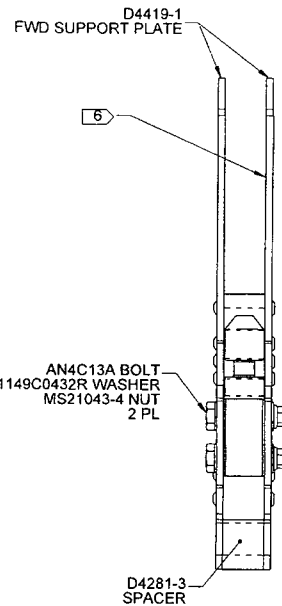
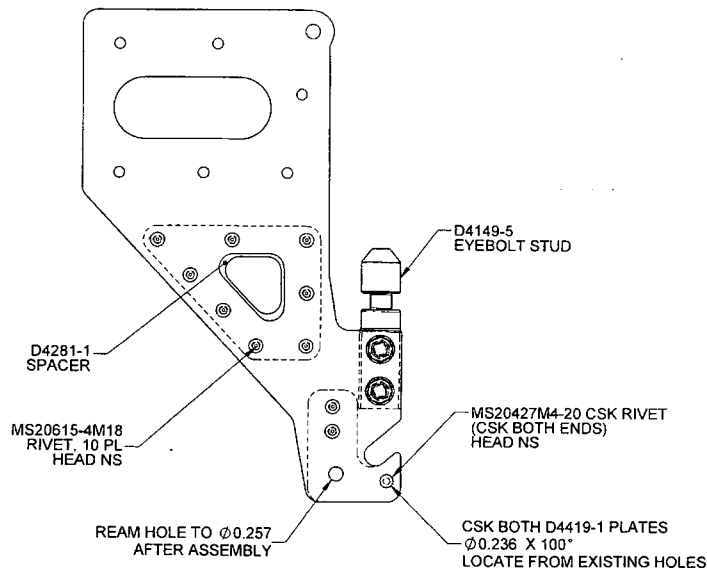
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NOTE: Date & initial all entries

2270

ITEM	QTY -025	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



RELEASED
2011-07-28

D4271-025 FWD BEAM END FITTING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4271	REV. D
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES	
DATE	11.07.14	NTS	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

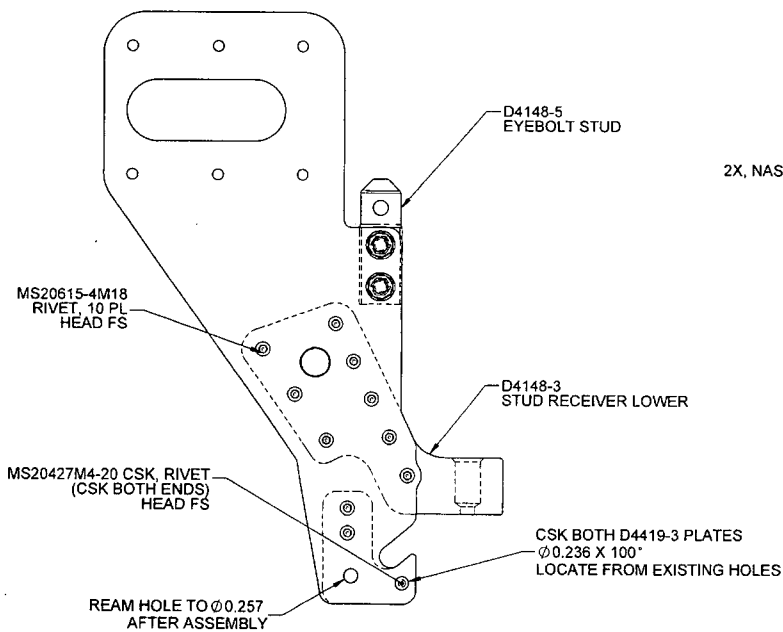
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2550

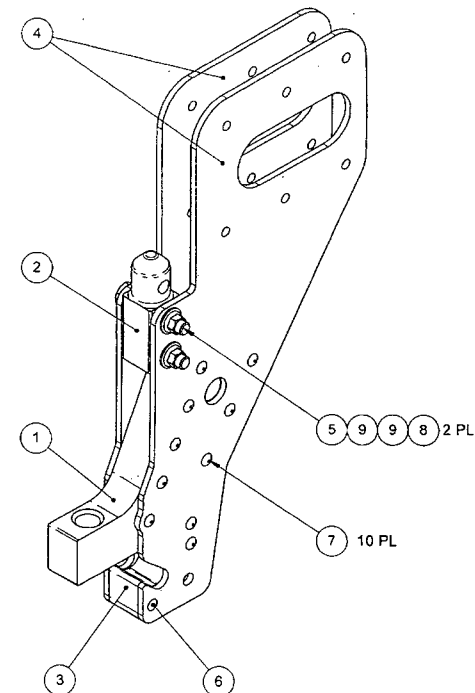
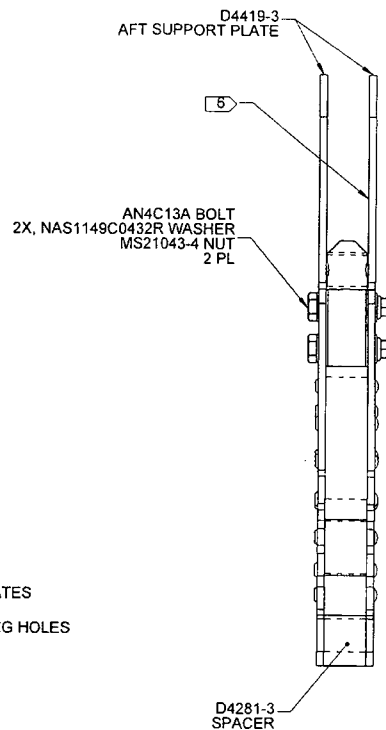
ITEM	QTY -027	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



D4271-027 AFT BEAM END FITTING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



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2011-07-28

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MFG. APPR.	<i>[Signature]</i>	D4271	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SUPPORT BEAM ASSEMBLIES	NTS
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